



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.9710

Job Sheet 185799



Part No: 646.9710

Job Qty: 10 ea

Part Name: Body



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 11/2/18

Job Tracking No:

Due Date: 11/16/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E SHEETS 1-4 IPP REV:A NEW ISSUE 12/10/04 JFS VERIFY BY: DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		DAS Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	11/16/18	11/16/18	0.00	0.00	Start Up Machining-1		52 18/11/14
110	CNC Vertical Machining	10 pcs	11/16/18	11/16/18	0.22	5.00	HAAS1-1		9-89 18/11/14
120	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC2 Machining-1		18/11/14
130	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC8 Machining-1		18/11/14
140	Outsource	10 pcs	11/16/18	11/16/18			ATG001-VC	10	DEC 13-11-2018
150	Packaging	10 pcs	11/16/18	11/16/18	0.00	0.00	Packaging2		DEC 13-11-2018
155	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC6		61
160	SprayPaint	10 pcs	11/16/18	11/16/18	0.00	1.67	Spray Paint		9-89
165	QC	10 pcs	11/16/18	11/16/18	0.00	0.00	QC14		6
180	Packaging	10 pcs	11/16/18	11/16/18	0.00	0.00	Packaging3-1		9-89
190	QC21-SA	10 Ea	11/16/18	11/16/18	0.00	0.00	QC21		9-89

Part Op 90 - Cut Blank at 7.425"

Descriptions: 110 - 1-Machine per folio FB130

140 - Issue P/O to ATG : _____ Hard Black Anodize Color Black and Prime as per Dwg 646.9700

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6S1.000X5.000	7075-T6 Sheet1" Thick Plate X 5" Wide	6.2100 ft (.621 ea)	90-Start up Operation	512.9443

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6S1.000X5.000	6	7	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Body	0.130Inches $\pm$ 0.010	0.140 0.120	0.130	
2	Body	45.0Angle $\pm$ 0.5	45.5 44.5	45°	
3	Body	1.500Inches $\pm$ 0.005	1.505 1.495	1.500	

*QA Closed: _____ Date: _____

Work Order update only

Work Order: _____		DISPOSITION		AGAINST DEPARTMENT/PROCESS																																																																																											
Part No. _____		Rework ☐		Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐																																																																																								
NCR No. _____		Scrap ☐		Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐																																																																																								
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Dart Aerospace Ltd. 1270 Aberdeen Street Newbury, ON K6A 1K7 CANADA TEL.: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Date: 11/24/16				Completed By																																																																																											
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OTHER :																																																																																															

4	Body	0.352Inches + 0.005 - 0.000	0.357 0.352	0.352
5	Body	0.100Inches ± 0.010	0.110 0.090	0.100
6	Body	45.0Angle ± 0.5	45.5 44.5	45°
7	Body	0.875Inches ± 0.005	0.880 0.870	0.874
8	Body	0.700Inches ± 0.005	0.705 0.695	0.699
9	Body	5.500Inches ± 0.005	5.505 5.495	5.500
10	Body	0.660Inches ± 0.005	0.665 0.655	0.660
11	Body	0.660Inches ± 0.005	0.665 0.655	0.656
12	Body	0.278Inches ± 0.002	0.280 0.276	0.278
13	Body	0.339Inches ± 0.002	0.341 0.337	0.339
14	Body	0.352Inches ± 0.002	0.354 0.350	0.352
15	Body	0.372Inches ± 0.002	0.374 0.370	0.372
16	Body	1.067Inches ± 0.002	1.069 1.065	1.067
17	Body	2.608Inches ± 0.002	2.610 2.606	2.608
18	Body	2.750Inches ± 0.002	2.752 2.748	2.750
19	Body	2.892Inches ± 0.002	2.894 2.890	2.892
20	Body	3.348Inches ± 0.002	3.350 3.346	3.348
21	Body	3.597Inches ± 0.002	3.599 3.595	3.597
22	Body	3.847Inches ± 0.002	3.849 3.845	3.847
23	Body	0.351Inches ± 0.002	0.353 0.349	0.351
24	Body	0.544Inches ± 0.002	0.546 0.542	0.544
25	Body	2.195Inches ± 0.002	2.197 2.193	2.195
26	Body	2.304Inches ± 0.002	2.306 2.302	2.304
27	Body	2.451Inches ± 0.002	2.453 2.449	2.451
28	Body	2.639Inches ± 0.002	2.641 2.637	2.639
29	Body	3.395Inches ± 0.002	3.397 3.393	3.395
30	Body	3.495Inches ± 0.002	3.497 3.493	3.495
31	Body	4.551Inches ± 0.002	4.553 4.549	4.551
32	Body	4.595Inches ± 0.002	4.597 4.593	4.595
33	Body	4.687Inches ± 0.002	4.689 4.685	4.687
34	Body	4.734Inches ± 0.002	4.736 4.732	4.734
35	Body	6.651Inches ± 0.002	6.653 6.649	6.651
36	Body	0.201Inches + 0.005 - 0.001	0.206 0.200	0.202

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

*QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
				Completed By					
				Lead hand / Supervisor Approval Verification					
				QC / QA Coordinator Approval					

Root Cause				FAULT CATEGORY			
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____			
Misidentified	☐	Past Due	☐				

37	Body	0.177Inches + 0.005 - 0.001	0.182 0.176	0.178
38	Body	7.026Inches ± 0.005	7.031 7.021	7.027
39	Body	4.245Inches ± 0.005	4.250 4.240	4.246

Plex 11/2/18 10:18 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

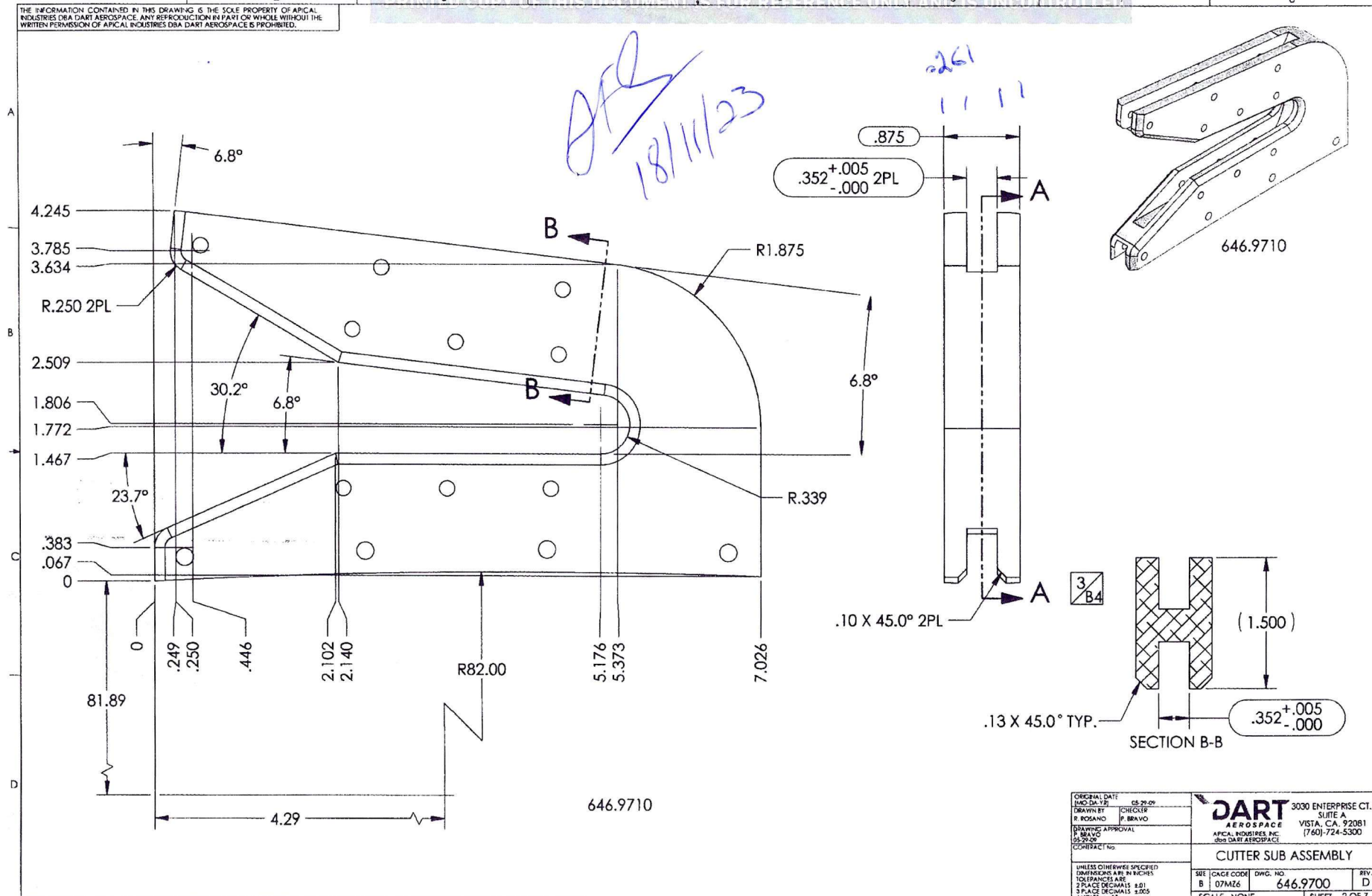
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐																				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____																							
Misidentified ☐	Past Due ☐																								

THE INFORMATION CONTAINED IN THIS DRAWING IS THE SOLE PROPERTY OF APICAL INDUSTRIES DBA DART AEROSPACE. ANY REPRODUCTION IN PART OR WHOLE WITHOUT THE WRITTEN PERMISSION OF APICAL INDUSTRIES DBA DART AEROSPACE IS PROHIBITED.

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AFB
18/11/23

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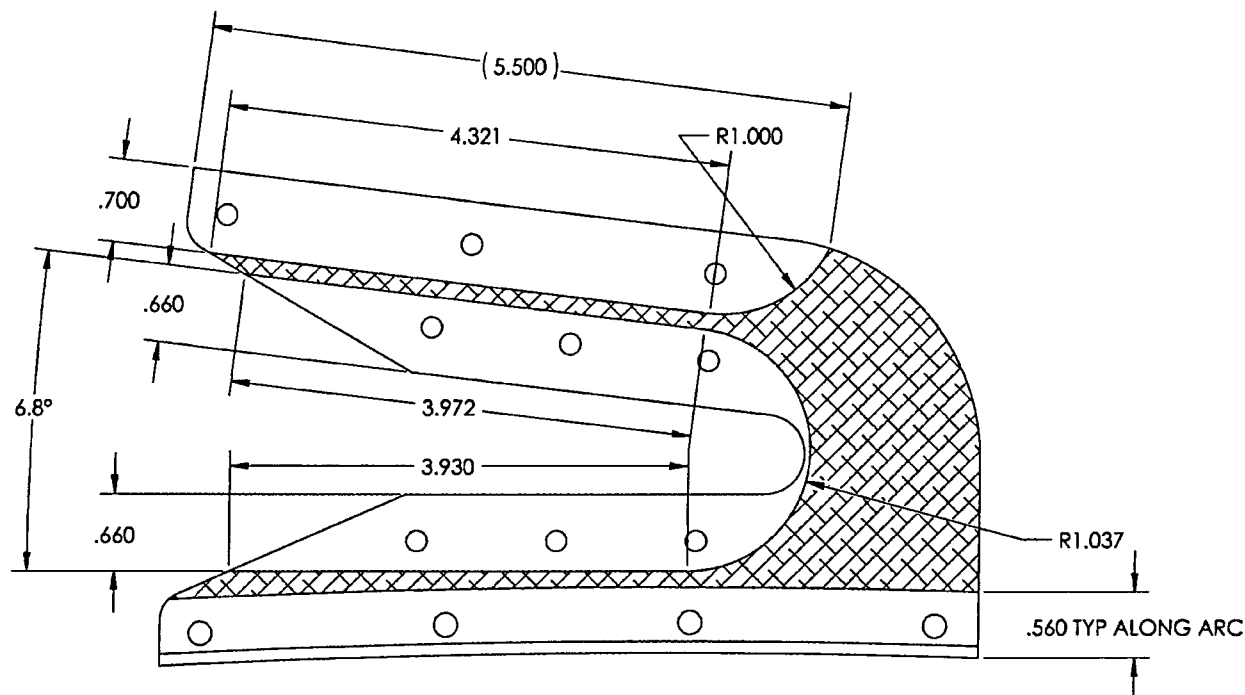


ORIGINAL DATE (M/D/YR)	CS-27-09	 DART AEROSPACE 3030 ENTERPRISE CT. SUITE A VISTA, CA 92081 (760)-724-5300 APICAL INDUSTRIES INC. (DBA DART AEROSPACE)			
DRAWN BY R. ROSANO	CHECKER P. BRAVO				
DRAWING APPROVAL P. BRAVO 05-29-20					
CONTRACT# No.					
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5°					
CUTTER SUB ASSEMBLY		SHEET B	CAGE CODE 07MA26	DWG. NO. 646.9700	REV. D
SCALE NONE		SHEET 2 OF 7			

M7075T6S1.000X5.000
S129443

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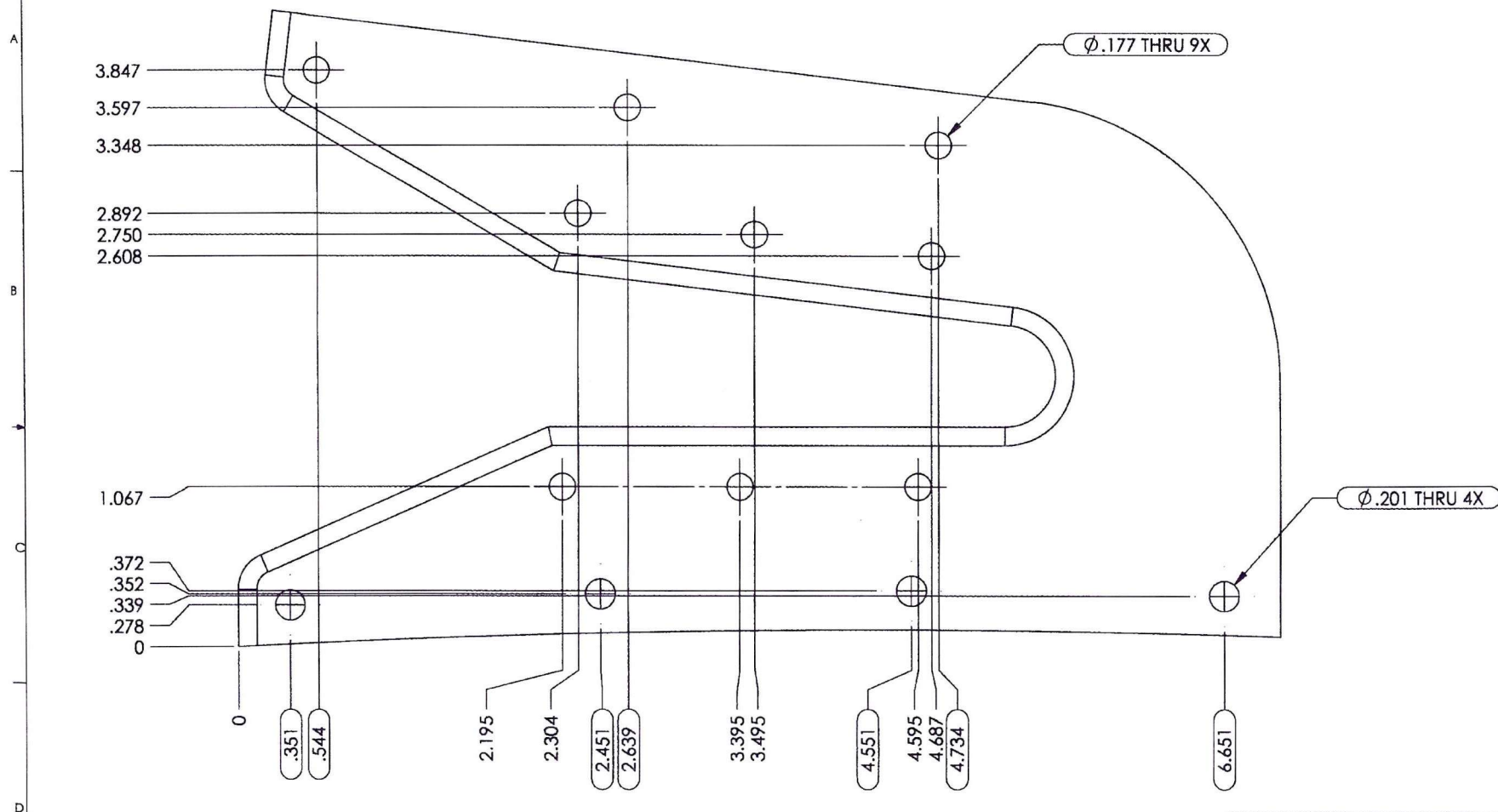
SECTION A-A $\frac{2}{C8}$

646.9710

ORIGINAL DATE 10/24/09		3030 ENTERPRISE CT., SUITE A VISTA, CA. 92081 (760)-724-5300	
DRAWN BY R. ROIANO		CHECKED P. BRAVO	
DRAWING APPROVAL P. BRAVO		APICAL INDUSTRIES INC. DBA DART AEROSPACE	
CONTRACT NO.		CUTTER SUB ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ± .01 2 PLACE DECIMALS ± .005 ANGLES ± .5°		SEE CAGE CODE B 07M16	QWG. NO. 646.9700
SCALE: NONE		REV. D SHEET 3 OF 7	

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HOLE LOCATIONS +/- .002

646.9710

ORIGINAL DATE 1/10/2010		3030 ENTERPRISE CT., SUITE A, VISTA, CA 92081 (760) 724-5300	
DRAWN BY P. ROSANO	CHECKED P. BRAVO	DART AEROSPACE APICAL INDUSTRIES, INC. DBA DART AEROSPACE	
DRAWING APPROVAL P. BRAVO 05-27-09			
CONTRACT NO.		CUTTER SUB ASSEMBLY	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 3 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ± .5°		SHEET B 07M16	REV. D
SCALE NONE		SHEET 4 OF 7	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041883**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

Attention: Lalande, Marc-Andre

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO041883
PO Date: 11/28/18
Due Date: 12/11/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, Chrisoula
Phone:
Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

*revised PO

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	178970	RBE703A94-1130-01-27	Tab Adjuster Body -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 Water seal -Certificate of Conformity is required	Firmed	-	11/30/18	5 pcs	0 pcs	5 pcs	\$5.80/pcs	\$29.00
5X NOV 30 2018											
Line Item Note ** ASAP by Friday morning **											
2	184442	RBT18601	Main Rotor Swashplate ReGreasing Tool -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE-2 CLASS-2, Water sealant -Material type; -Certificate of Conformity is required	Firmed	-	11/30/18	8 pcs	0 pcs	8 pcs	\$5.80/pcs	\$46.40
8X NOV 30 2018											
Line Item Note ** ASAP by Friday morning **											



Dart Aerospace Ltd.
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Hawkesbury, ON
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Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041883**

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	185913	C45-1-1	Manual Knob Release -Issue P/O to ATG; PO -ANODIZE COLOR RED, PER IAW MIL-A-8625 TYPE- 2 CLASS-2, Water sealant -Material type; 6061 -Certificate of Conformity is required As Per DWG C45- 1-1	Firmed	-	11/30/18	10 pcs	0 pcs	10 pcs	\$5.80/pcs	\$58.00
Line Item Note ** ASAP by Friday morning **											
4	185767	646.3812	Gusset Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO041883**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
5	185768	646.3813	AS350 Strut Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A-8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs	0 pcs	20 pcs	\$7.20/pcs	\$144.00
6	186252	650.9201	Eyelet Bracket Assembly Issue P/O to ATG : Hard Anodize, Color Black and Prime as per Dwg 650.9200	Firmed	-	12/6/18	20 pcs	0 pcs	20 pcs	\$7.70/pcs	\$154.00
7	186245	646.3610	Filler Issue P/O to ATG : 1- Hard Anodize Black and Prime as per Dwg 646.3600	Firmed	-	12/11/18	16 pcs	0 pcs	16 pcs	\$7.70/pcs	\$123.20



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PURCHASE ORDER **PO041883**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
8	185766	646.3810	Bracket Issue P/O to ATG: AS PER MPP-172 SECTION 2.1, HARD ANODIZE COLOR BLACK, PER IAW MIL-A- 8625 TYPE 3 CLASS 2 AS PER MPP-172 SECTION 4.3, PRIME CARDINAL 7760-4702 LOW VOC EPOXY PRIMER (LIGHT GRAY) Certification of Conformity is required	Firmed	-	12/5/18	20 pcs 21	0 pcs	20 pcs	\$7.65/pcs	\$153.00
9	185799 185794-A	646.9710	Body Issue P/O to ATG : Hard Black Anodize Color Black and Prime as per Dwg 646.9700	Firmed	-	12/6/18	10 pcs 10	0 pcs	10 pcs	\$15.60/pcs	\$156.00
10	186661	RBT112800-1	Base -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL As per Dwg RBT112800 Rev. 3A -Certificate of Conformity is required	Firmed	-	12/6/18	13 pcs 13	0 pcs	13 pcs	\$5.80/pcs	\$75.40
Grand Total:											\$1,083.00



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PURCHASE ORDER PO041883

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 11/30/18 10:12 AM dart.tsimiklis.chrisoula



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

Fax: (613) 446-4556

Pack List

Number: 916824

Date: 17-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Chrisoula Tsimiklis
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
10 ea	Part: 646.9710 ✓ Body Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (1 - 2 mils) per drawing. Job: 24232 PO: PO041883 ✓ Rev: D Line: 9	DAS 61 9-89	
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>17/12/2018</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt. Made in Canada.			